



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-100
Job Sheet 180036



Part No: SWA10A-100

Job Qty: 8 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 7/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA10A-100 Rev 10 IPP Rev A 17.12.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	8 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	8 pcs	7/13/18	7/13/18	0.00	8.00	MORI NLX		
120	QC	8 pcs	7/13/18	7/13/18	0.00	0.00	QC2		
130	QC	8 pcs	7/13/18	7/13/18	0.00	0.00	QC8		
140	Packaging	8 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3		
150	QC21-SA	8 Ea	7/13/18	7/13/18	0.00	0.00	QC21		

Part Op 110 - Cut blanks to 7.00" 1-Machine as per FOLIO. FC056 FOLIO REV: _____ DWG REV: 9-00 JUL 12 2018
Descriptions: 2-Deburr 3-***Please see PEC to change engraving batch # for every w/o**

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.750	17-4 SS H1150 Round Bar 2.750"	4.6400 ft (.58 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R2.750	5	1	0

Part Specifications

Specifications could not be found.

Plex 6/28/18 7:00 AM Dart.lajeunesse.marie



Container No: S088516



Part: SWA10A-100

Job No: 180036

Serial No/Batch: S088516

Revision: 10

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/29/18

93/100
10-06-29 @ 1:00
3/14

DART AEROSPACE LTD		Work Order: 180036
Description: Lower End		Part Number: SWA10A-100
Inspection Dwg: SWA10A-100		Rev: 10 Page 1 of 3

INSPECTION SHEET

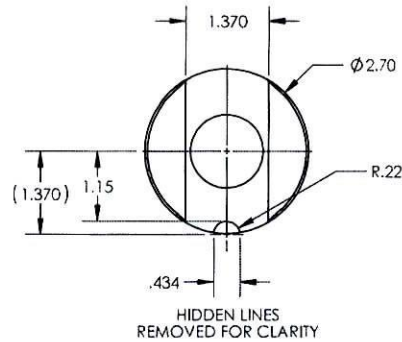
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.020	+0.015 / -0.010	1.022	✓		Mic LPD4	
1.350	±0.005	1.350			H.G.	
.03x45°	±0.010 x .5°	.032x45°			Vern LPD9	
2.69	±0.01	2.689			↓	
1.735	±0.005	1.735			↓	
1.963	±0.001	1.963			Mic LPD2	
.395	±0.005	.395			Vern LPD9	
2.3155	±0.0025	2.3145			H.G.	
Ø2.70	±0.01	2.700			Vern LPD9	
1.370	±0.005	1.370			↓	
1.15	±0.01	1.150			↓	
.434	±0.005	.438			↓	
R.22	±0.01	.219			↓	
.820	±0.005	.820			↓	
.04 x 45°	±0.01 x .5°	.042x45°			Vern LPD9	
10-32 UNF-2B	GO-NOT GO	GO			↓	
.25	±0.01	.250			↓	
Ø.500	±0.005	.500			↓	
1.35	±0.01	1.360			H.G.	
.200	±0.005	.1985			↓	
3.10	±0.01	3.100			↓	
3.25	±0.01	3.2475			↓	
3.70	±0.01	3.700			↓	
6.87	±0.01	6.867			Vern LPD	
R.13	±0.01	.125			Rad gage	
					↓	
R.03	±0.01	.032			Vern LPD9	
.03x45°	±0.01 x .5°	.03x45°				

Measured by: <i>[Signature]</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 18-06-29	Date: 18/07/10	Date:

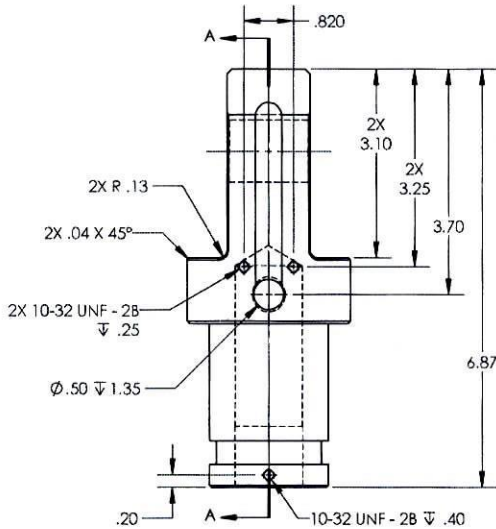
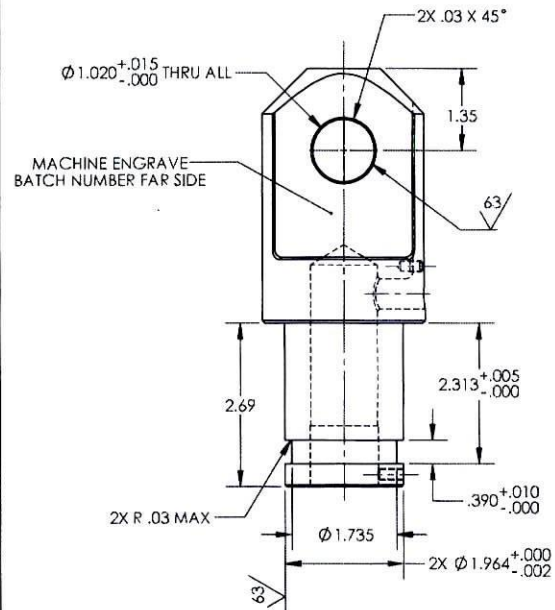
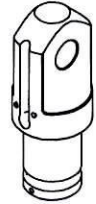
Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

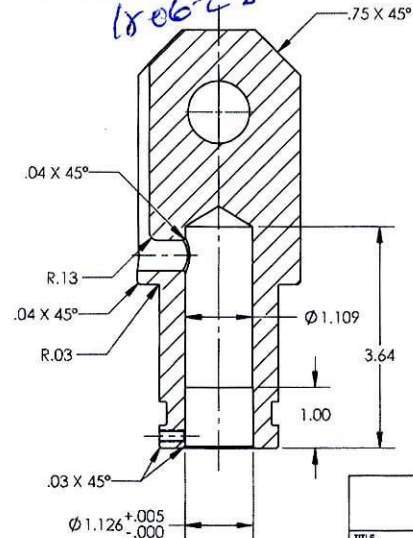
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
8		AS DRAWN BY CANAM	11/12/2012	JAG
BA		CHD B/O TO SWA10A-100 BLANK	5/1/2014	JAG
9	15-016	UPDATED TO NEW DRAFTING STANDARDS. ADDED MATL OPTION 17-4 H1075. REMOVED SWA10A-100 BLANK FROM B/O. ADDED DIMS FROM SWA10A-100 BLANK. CHD TOLERANCES ON NON-CRITICAL DIMENSIONS.	7/17/2015	DPD
10	16-0243	ADDED MACHINE ENGRAVE BATCH NUMBER FAR SIDE NOTE.	12/1/2016	RJC



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1800364125
180625



SECTION A-A

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-100	1	LOWER END	SS 17-4 H1150/17-4 H1075	

DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA10A-100	REV 10
MATERIAL: SS 17-4 H1150/17-4 H1075	
FINISH: .XXX ± .005 FRACTIONS ± 1/8	
FINISH: .XX ± .01 ANGLES ± 5°	
FINISH: .X ± .1 SURFACES ± 125	
SPEC: 1. BREAK ALL SHARP EDGES	
SPEC: 2. DIMENSIONAL LIMITS APPLY	
SPEC: 3. INTERPRET DIM AND TOL PER	
SPEC: ASME Y14.5M-2009	
SPEC: USED ON MODEL	
DRAWN BY: CANAM	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE: 1.2	DATE: 1/22/2002
SHEET 1 OF 1	